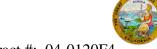
#### DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

# WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-013687 Address: 333 Burma Road **Date Inspected:** 26-Apr-2010

City: Oakland, CA 94607

**OSM Arrival Time:** 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name: CWI Present:** Yes No N/A **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A Yes N/A **Electrode to specification:** No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No Yes No N/A **Delayed / Cancelled:** 

34-0006 **Bridge No: Component: OBG COMPONENT** 

### **Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay#19

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG U-rib connecting plate, weld No.USPL1-594-001. The welder is identified as #062788. ZPMC QC is identified as Mr. Zhoe Chang. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW in the 2G position for the OBG U-rib connecting plate, weld No.USPL1-596-002. The welder is identified as #062807. ZPMC QC is identified as Mr. Zhoe Chang. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW in the 2G position for the OBG U-rib connecting plate, weld No.USPL1-599-001. The welder is identified as #062783. ZPMC QC is identified as Mr. Zhoe Chang. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW in the 2G position for the OBG Suspender Bracket SB52E, weld No.SB014-052-005. The welder is identified as #062749. ZPMC QC is identified as Mr. Zhoe Chang. The welding variables recorded by QC appear

# WELDING INSPECTION REPORT

(Continued Page 2 of 2)

to comply with WPS-B-T-2232-Tc-U4b-F.

During in-process observations of the Cross Beam Bottom panels being fabricated in bay 19, the Caltrans Quality Assurance Inspector (QA) observed that the Cross Beam Bottom panels distortion due to improper storage in Bay 19. The Crossbeam bottom plate material is A709 Grade 345 Seismic Performance Critical Material (SPCM). For more information see the attached photo.

Magnetic Particle Testing (MPT)

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG Cross Beam Bottom Plate to Stiffener. This QA inspector generated a (MT) report for this date . This weld was previously tested and accepted by ZPMC QC MT technicians.

The weld designations reviewed are as follows:

BP026-010-004~023,044~053 BP026-012-004~023,044~053

Green Tagging

This QA inspector performed Visual Inspection for Green Tagging which were previously tested and accepted by ZPMC Quality Control personnel and ABF QA personnel. The members are identified as OBG Cross Beam Bottom Plate to Stiffener.

**OBG** Bottom Plate Green Tag

BP026-010-004~023,044~053 12344 BP026-012-004~023,044~053 12341

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### **Summary of Conversations:**

No relevant conversations

#### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera, Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson, Rodney	QA Reviewer